

4/26/2019
APR 17 2019



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RBT400203-E
Job Sheet 194195



Part No: RBT400203-E

Job Qty: 2 pcs

Part Name: Spring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/31/19

Description:

Type: Stock

Note: DWG RBT400203 Rev.5 IPP Rev. A 19.01.22 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	5/31/19	5/31/19	0.00	0.40	Waterjet - Flow	5/17/19	JRB
110	QC 2	2 pcs	5/31/19	5/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48	5/17/19	JRB
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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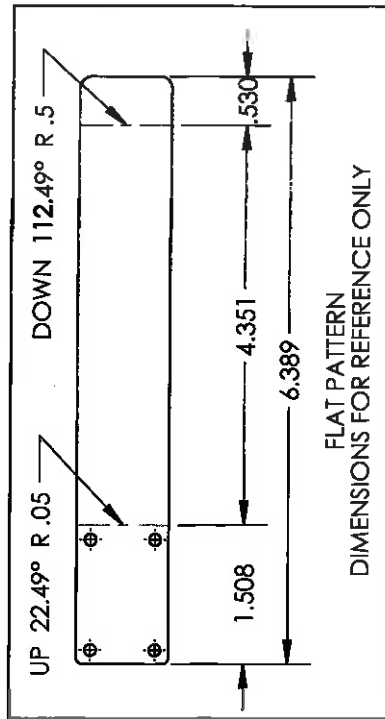
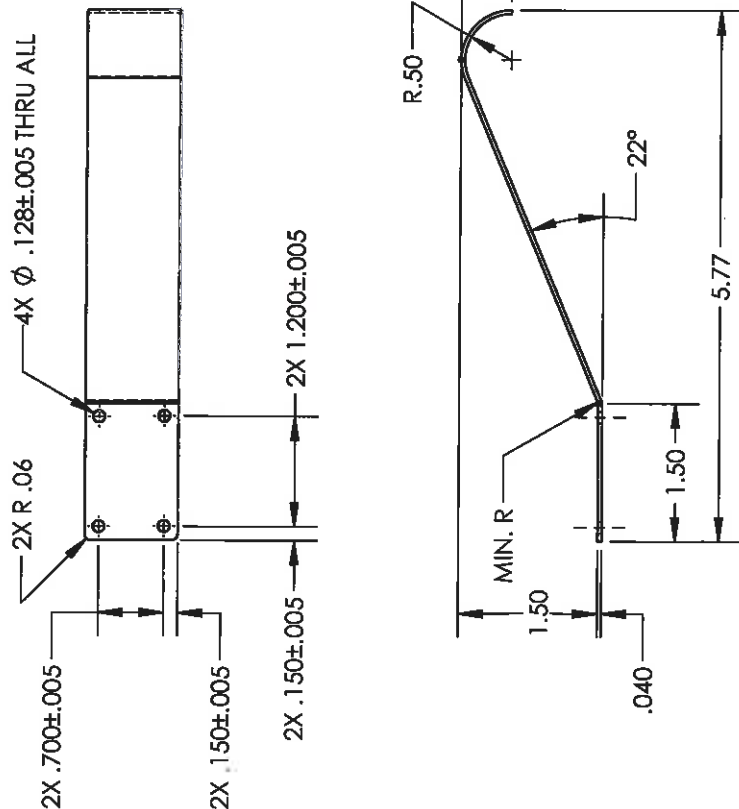
120 QC 8	2 pcs	5/31/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	AUG 15 2019
				QC 8 - 52	DAS 40 8-89
				QC 8 - 23	
130 Small Fab - 2 - B4B	2 pcs	5/31/19	0.00 0.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	2 pcs	5/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	OCT 22 2019
				QC 5 - 9	DAS 68 9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Packaging 3-1 - Stock - B4B	2 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	2 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>5</u> PROG. Rev: <u>5</u> 2-Deburr if necessary					DAS 21 9-29
Descriptions: 130 - Form as per DWG.					OCT 24 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M301S19GA	301 SS Sheet 1/2 Hard (.040)	.0888 sf (.0444 ea)	100-Waterjet - Flow - 1	3059764	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M301S19GA	0	51	0	
Part Specifications					
Specifications could not be found.					

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REV		ECR	REVISIONS	
			DESCRIPTION	
2			ADDED OUTSIDE RADIUS TO -E.	DATE INITIAL APPROVED
3			REMOVED -E FLAT LAYOUT AND SUPPLIED MISSING OVER ALL DIMENSION.	1/9/2008 WP RW
4			ADDED +/- .030 LIMITS TO DIMS (1.50, 5.76, .54, R.5), ADDED MISSING ANGLE DIM 22°.	4/20/2009 WP RW
5	16-0027		-E CHD TO SHEET METAL TOLERANCES. DELETED SAME SPRING CLIP USED ON T101 656 NOTE.	2/13/2013 BIM SE
				2/9/2016 DPD SM



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WITHOUT NOTICE
WORK ORDER
NO. 19979145
190426



TRIM TAB BENDING GAUGE

TITLE	REV
DWG NO.	5
MAT'L	RBT400203-E
FINISH	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
XXX ± .010 FRACTIONS ± 1/8	
XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES ± 125/	
1. BREAK ALL SHARP EDGES	
.015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY	
3. AFTER PLATING AND TOL PER	
ASME Y14.5M-2009	
DRAWN BY: COLE	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
USED ON MODEL	
BELL 206	
SCALE	1:2
DATE	1/10/2002
SHEET 7 OF 11	

SPRING CLIP





Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
				Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				

